

Date: Friday, 13/02/2009 12:58:01 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM ASSEMBLY
Job Number	: 45784	Part Number	: D2795043
Estimate Number	: 13791	Drawing Number	: D2795 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 13/02/2009	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 20/02/2009
Previous Run	:	Qty:	4
Written By	:	Um:	Each
Checked & Approved By	: <u>JUL 09.02.13</u>		
Comment	: Est Rev:A New Issue 09-02-11 JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00	 (4)
Comment: Qty.: 1.4438 f(s)/Unit Total: 2.8875 f(s) 6061-T6 Bar .500 x 6.00 BATCH: M110 9/2 Mat not entered in computer H.A 09/02/20			
2.0	BAND SAW	BAND SAW	 (4)
Comment: BAND SAW Cut blank 16.500" long H.A 09/02/20			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA804 Rev: B & Dwg D2795 Rev: B JL/H.A 09/02/24			
2-Deburr per dwg D2795 JL/H.A 09/02/24			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL/H.A 09/02/24			
5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE C'SINK AS PER DWG D2795 JL/J.L 09/02/24			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 12:58:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 45784

Part Number: D2795043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/02/24

(1)

7.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09/02/24

(4)

8.0 D2808 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

BATCH: B41708



(P6)

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

PRESS BUSHING AS PER DWG D2795

09/02/25

(1)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/25

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 151

09/02/26

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



09/02/26

09/02/26

Job Completion



09/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.02.25 7.5	8.0	Chemical conversion coat per QSI 005 <i>Perm change</i>	MD/BK	09/02/25 ④		09/02/25	09/02/25
		QC3	S. Wicks			09/02/25	09/02/25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	45784
Description: arm assembly	Part Number:	D2795-3
Inspection Dwg: D2795 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.496	✓			
6.501	$\pm .010$	6.502	✓			
4.369	$\pm .010$	4.370	✓			
.800	$\pm .010$.800	✓			
2.311	$\pm .010$	2.311	✓			
$\phi .191$	$\pm .005$.193	✓			
4.320	$\pm .010$	4.321	✓			
2.500	$\pm .010$	2.501	✓			
.250	$\pm .010$.251	✓			
15.506	$\pm .010$	15.504	✓			
13.57	$\pm .030$	13.571	✓			
.250	$\pm .010$.248	✓			
.250	$\pm .010$.248	✓			
.125	$\pm .010$.125	✓			
1.00	$\pm .030$	1.001	✓			
2.96	$\pm .030$	2.966	✓			
2.70	$\pm .030$	2.70	✓			
$\phi .157$	$\pm .045$.158	✓			
1.626	$\pm .010$	1.627	✓			
.440	$\pm .010$.441	✓			
.575	$\pm .010$.575	✓			
.625	$\pm .010$.625	✓			
1.250	$\pm .010$	1.250	✓			

Measured by:	JL	Audited by:		Prototype Approval:	N/A
Date:	09/02/23	Date:	07/02/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	H5784
Description: Arm assembly	Part Number:	D27954
Inspection Dwg: A2795 Rev: B		Page 2 of 1

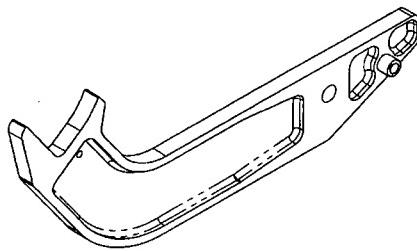
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

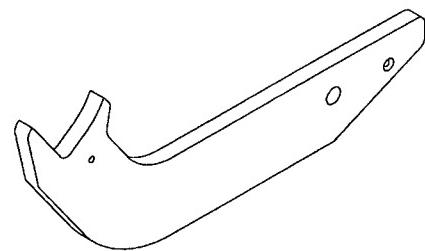
Measured by:	JL	Audited by:		Prototype Approval:	N/A
Date:	09/02/23	Date:	09/02/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

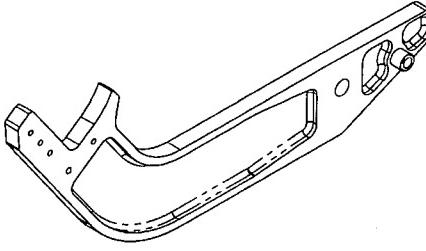
ITEM NO.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2795-041	ARM ASSEMBLY
2		X			D2795-042	ARM ASSEMBLY
3			X		D2795-043	ARM ASSEMBLY
4				X	D2795-044	ARM ASSEMBLY
11	1				D2795-1	ARM
12		1			D2795-2	ARM
13			1		D2795-3	ARM
15				1	D2795-4	ARM
21	1	1	1	1	D2808	SPACER



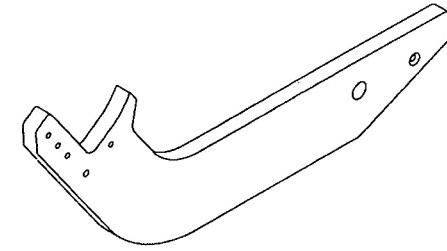
D2795-041 ARM ASSEMBLY



D2795-042 ARM ASSEMBLY



D2795-043 ARM ASSEMBLY



D2795-044 ARM ASSEMBLY

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NO. WRS 184

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2795-04X" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: D2795-041/-042 1.22 lbs
 D2795-043/-044 1.29 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. -1 & -2 PARTS HAD NO PHYSICAL CHANGES BUT WERE REDIMENSIONED. SEE PREVIOUS REV FOR DETAILS. -043, -044 -3 & -4 ADDED. MATERIAL SPECS UPDATED.			AJS	08.10.21
A	NEW ISSUE			DS	00.11.03
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			A
DRAWN	AJS	DRAWING NO.	D2795	REV. B	
CHECKED		REV. B		SHEET 1 OF 5	
MFG. APPR.		TITLE	ARM ASSEMBLY	SCALE	NTS
APPROVED		DATE	08.10.21	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.					

8 7 6 5 4 3 2 1

8

7

6

5

4

3

2

1

D2795-1
ARMD2795-2
ARMD2808
SPACER
PRESS FITD2808
SPACER
PRESS FITD2795-041 ARM ASSEMBLYD2795-042 ARM ASSEMBLYD2795-3
ARMD2795-4
ARMD2808
SPACER
PRESS FITD2808
SPACER
PRESS FITD2795-043 ARM ASSEMBLYD2795-044 ARM ASSEMBLY

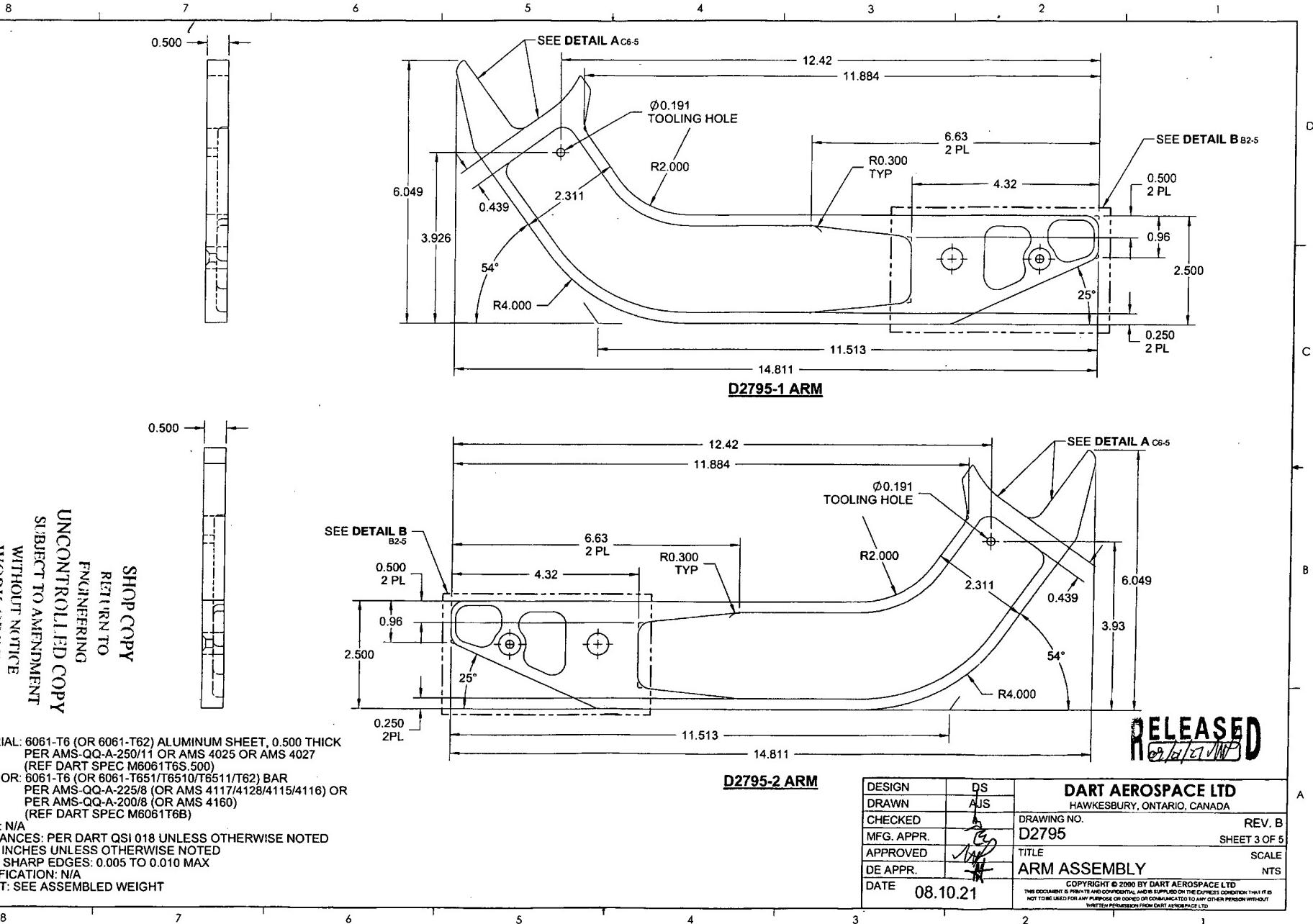
B

B

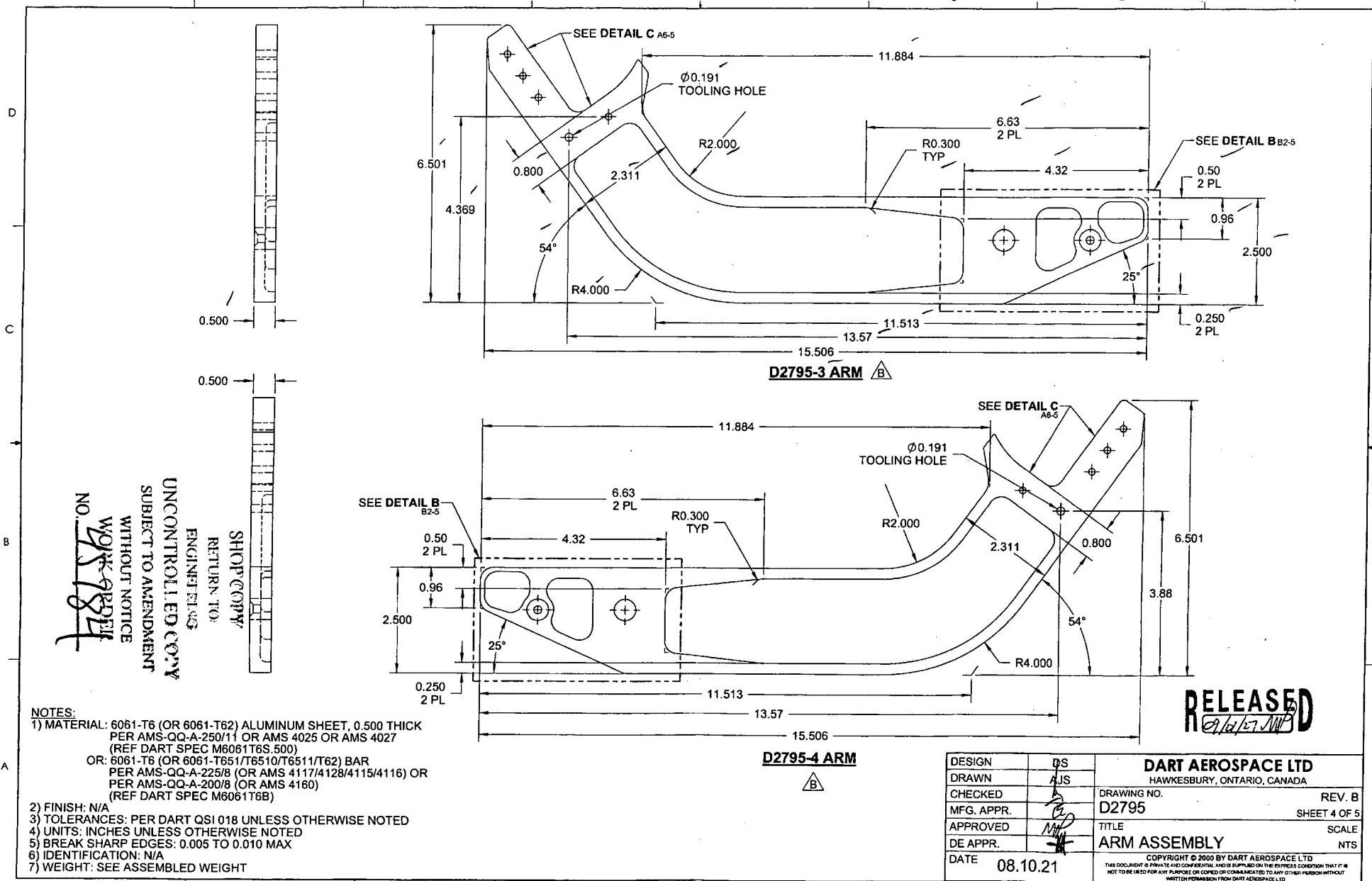
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RELEASED
09/01/2021

DESIGN	DS	DART AEROSPACE LTD
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D2795
DE APPR.		SHEET 2 OF 5
DATE	08.10.21	TITLE
		SCALE
		NTS
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

